

# Work Order ID 71872

Wednesday, July 13, 2011 11:03:04 AM



Page 1

Item ID: D1048

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: ME Date: 11-07-13

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D1048

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D1048

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-8-4

(27)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Suboslos

located  
(27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

*JS 11/08/23* (27)

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per dwg D2010 using DT8053

*JS 11/08/23* (27)

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*8/10/23*

*went*  
(22)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 71872**

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Accept



Setup Start



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Stop



Item Name: Saddle

Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

h/8/25  
CL1108/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, July 13, 2011 11:03:02 AM

Page 1

Work Order ID: 71872

Parent Item: D1048

Parent Item Name: Saddle



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B 02.02.22 Re-format NG  
IPP Rev: C Now on Waterjet 06-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

222.7000

0.018

0.378947



304/316 Sheet .063



1311-8-4

Location

Loc Qty

Loc Code

MAT020

22.7

117275

1.7

117653

21

MAT021

200

118217

200

118217

(27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
97/09/02 RCL

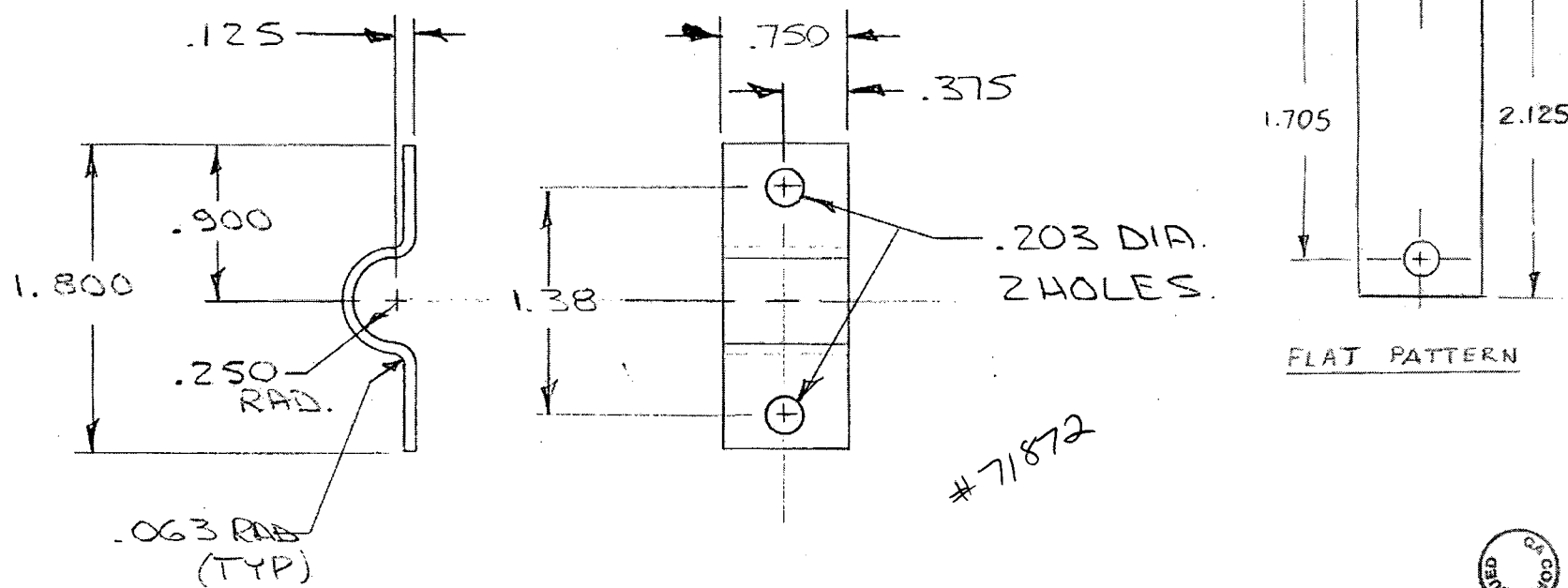
NOTES:

1) MATERIAL

STAINLESS STEEL  
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)  
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



A		REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC./VENOOR
RF		DRAWN			BASIC CODE		CONTRACT NO.				DART AERO ACCESSORIES INC. CANADA	
11		APPROVED			D=DIMPLE DASH=NO OF SHEETS C=COUNTERSINK		DATE 5/1/97					
01.12.05 ADD FLAT PATTERN		DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		STRESS				TITLE CLAMP	
			GENERAL		B=NAS20470AD DB=NAS20426AD		CHECKED				CODE D1048	
			LIMITS				CLIENT				REV. A	
			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 75/1 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER MIL. S. 3742 5. HOLES PER AND 10387		1. TOLERANCES — XX ± .030 XX ± .010 2. ANGLES 90° 3. PARALLELISM .0075 4. ECCENTRICITY .005 MAX. 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		SCALE 1:1		SHT 1 OF 1			
REPORT ALL DISCREPANCIES — DO NOT SCALE												

D1048

A

W/O:		WORK ORDER CHANGES					
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